



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D119-646-241
Job Sheet 192326



Part No: D119-646-241

Job Qty: 1 ea

Part Name: AW119 Replacement Skidtube with Heavy Duty Wearplates - Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/21/19

Job Tracking No:

Due Date: 4/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 14509*

Note: DWG IIN-D119-646 REV D, D3887-045 REV E SHEETS 4, 6-11 IPP RevA: New issue DD verified by:EC IPP REV B 12.11.05 (DEOD3887-B-1)(ecn 12-675) DD verf:JLM IPP REV:C 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:D 17.05.19 as per dwg D3887 rev.e DD verf:JFS

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S165251



Part: D119-646-241

Job No: 192326

Serial No/Batch: S165251

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 18/10/17, TC STC LoA P-09-0407-RDIMS-

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/10/19	0.00	0.00	Start Up Skid tubes-1		JW
110	Skid tubes	1 pcs		4/10/19	0.77	0.05	Skid tubes-1		JW
120	HandFinish	1 pcs		4/10/19	0.00	0.79	HandFinish1		D.R. 19/03/25
121	QC	1 pcs		4/10/19	0.00	0.00	QC7-1		JW
122	QC	1 pcs		4/10/19	0.00	0.00	QC5		BE
130	Skid tubes	1 pcs		4/10/19	0.00	2.38	Skid tubes-1		JW
135	QC	1 pcs		4/10/19	0.00	0.00	QC5		BE
140	Skid tubes	1 pcs		4/10/19	0.00	2.38	Skid tubes-1		MBG
150	QC	1 pcs		4/10/19	0.00	0.00	QC5		BE
160	Skid tubes	1 pcs		4/10/19	0.00	2.44	Skid tubes-1		BE, TF DAS
170	QC	1 pcs		4/10/19	0.00	0.00	QC5		APR 12 2019 68
180	QC	1 pcs		4/10/19	0.00	0.00	QC10		APR 12 2019 9-89
190	HandFinish	1 pcs		4/10/19	0.00	0.33	HandFinish2		D.R. 19/04/15
200	Powdercoat	1 pcs		4/10/19	0.00	0.20	Powdercoat1		BE 19-04-15
210	QC	1 pcs		4/10/19	0.00	0.00	QC3		MBG 19-04-16
240	HandFinish	1 pcs		4/10/19	0.00	0.79	HandFinish4		MBG 19-04-16
250	QC	1 pcs		4/10/19	0.00	0.00	QC5		
258	DC	1 pcs		4/10/19	0.00	0.00	DC		9-89 DAS
260	Packaging	1 pcs		4/10/19	0.00	0.00	Packaging3-1		9-89 DAS
270	QC21-FG	1 Ea		4/10/19	0.00	0.00	QC21		

Part Op 110 - 1- inspect Mat'L D2500-1-190 for damage 2-Cut tube to length as per dwg D3887 (154.8") 3- Ensure squareness of Descriptions: ends and scribe batch#

130 - 1- Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9477 4- Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes*** 5- Deburr, blow out chips from inside of tube. 6- Bond web in place as per Dwg D3887 & QSI 015. A/R Sikaflex-291 5163445 Sikaflex expire date: 4/23/19 Start: 03/27/19 Time: 12:30 PM Finish: 03/28/19 Time: 12:30 PM *****Adhere for 12 hours*****

140 - 1- Bend FWD end of tube using bender 1 and bend prog. D3887. ***Must use bending aid DT9544, ensure proper positioning*** 2- Cut FWD end of tube as per dwg D3887. ***Verify measurement*** 3- Buff out marks left from bending 4- Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208" 5- Open FWD saddle holes to finished size as per dwg D3887 6- Drill FWD x-bolt spacer holes using DT9816 and open to finished size. (verify measurement) 7- Drill Tow ring hole, using DT10047 locate from FWD saddle hole. (verify measurement). Open to finished size. 8- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 9- C'sink FWD cap hole as per detail "C" 10- Countersink crossbolt spacer holes, and prepare tube for welding, deburr. 11- Deburr and blow out chips from inside of tube.

160 - NOTE: TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE, IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1- Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/R Aluminum Rod 138989 2- Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole. 3- Counterbore x-bolt spacer holes as per Dwg D3887 using DT10279. 4- Deburr and blow out chips from inside of tube 5- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skid tube batch#.

170 - TEST FIT USING FIXTURE DT10091.

200 - ***MASK AREA SHOWN ON SHEET 7, NOTE 9*** START TIME: 4:00 OVEN TEMPERATURE: 300 FINISH TIME: 4:00 M 151749

240 - 1- Install wearplates as per Dwg D3887. 2- Inspect for foreign objects as per QSI 024 3- Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 5163445 Sikaflex expire date: 19-4-23 4- Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 5163445 Sikaflex expire date: 19-4-23 5- INSPECT TORQUE ON BOLTS AS PER DWG.

BY: DATE: 6-Wing Walk as per dwg QSI005 4.4 Batch: 5163430

258 - Photocopy bluefile & type labels per PPP D119-646-241 CHG005

260 - Location : FG108

DAS
68
9-89
DAS
15
9-89

Fglas

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -1" Beam Tube 4"	1 pcs (1 ea)	90-Start up Operation	5112963
D2579	Crossbolt Spacer	2 pcs (2 ea)	140-Skidtubes	5097840
D3885-1	Standard Web	1 pcs (1 ea)	140-Skidtubes	5088677
D3681-1	Spacer	12 pcs (12 ea)	160-Skidtubes	3145873
D3903-1	Spacer	12 pcs (12 ea)	160-Skidtubes	3144956
ALS4-1032-225	Rivnut	1 Ea (1 ea)	240-HandFinish	5059809
AN3C46A	Bolt	8 Ea (8 ea)	240-HandFinish	5095398
AN3C5A	Bolt	2 Ea (2 ea)	240-HandFinish	5149186
D2855-3	Cap	1 pcs (1 ea)	240-HandFinish	5126463
D2855-5	Cap	1 pcs (1 ea)	240-HandFinish	5002078
D3492-045	Plug Assembly	8 pcs (8 ea)	240-HandFinish	5040473
D3672-1	Washer, Phenolic	2 pcs (2 ea)	240-HandFinish	5169287
D3849-041	Fwd Heavy-Duty Wearplate, Std Skid Compatible	1 pcs (1 ea)	240-HandFinish	5116656
D3849-043	Aft Heavy-Duty Wearplate, Std Skid Compatible	1 pcs (1 ea)	240-HandFinish	5141322
D3904-1	Washer	16 pcs (16 ea)	240-HandFinish	5099569
MS21043-3	Nut	8 Ea (8 ea)	240-HandFinish	5164608
MS24694-C52	Screw	2 Ea (2 ea)	240-HandFinish	5067269
NAS1149C0332R	Washer	2 Ea (2 ea)	240-HandFinish	5148669

609292

Job Allocations

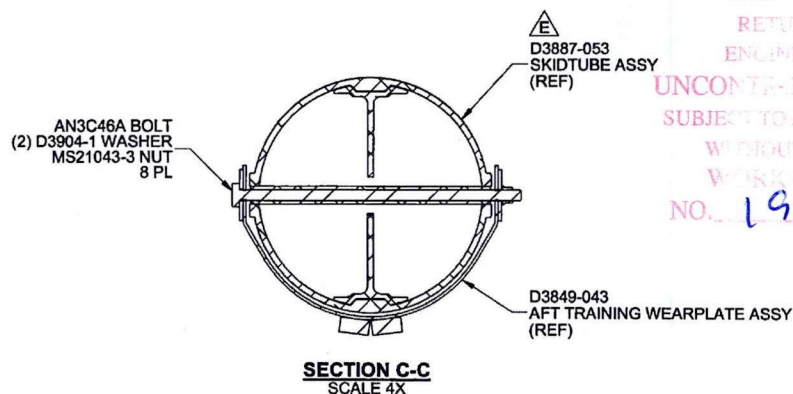
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-190	1	32	0
140-Skidtubes	D2579	2	118	0
	D3885-1	1	7	0
160-Skidtubes	D3681-1	12	204	0
	D3903-1	12	151	0
240-HandFinish	ALS4-1032-225	1	937	0
	AN3C46A	8	201	0
	AN3C5A	2	1,437	0
	D2855-3	1	32	0
	D2855-5	1	52	0
	D3492-045	8	36	0
	D3672-1	2	1,881	0
	D3849-041	1	1	0
	D3849-043	1	7	0
	D3904-1	16	64	0
	MS21043-3	8	941	0
	MS24694-C52	2	82	0
	NAS1149C0332R	2	5,033	0

Part Specifications

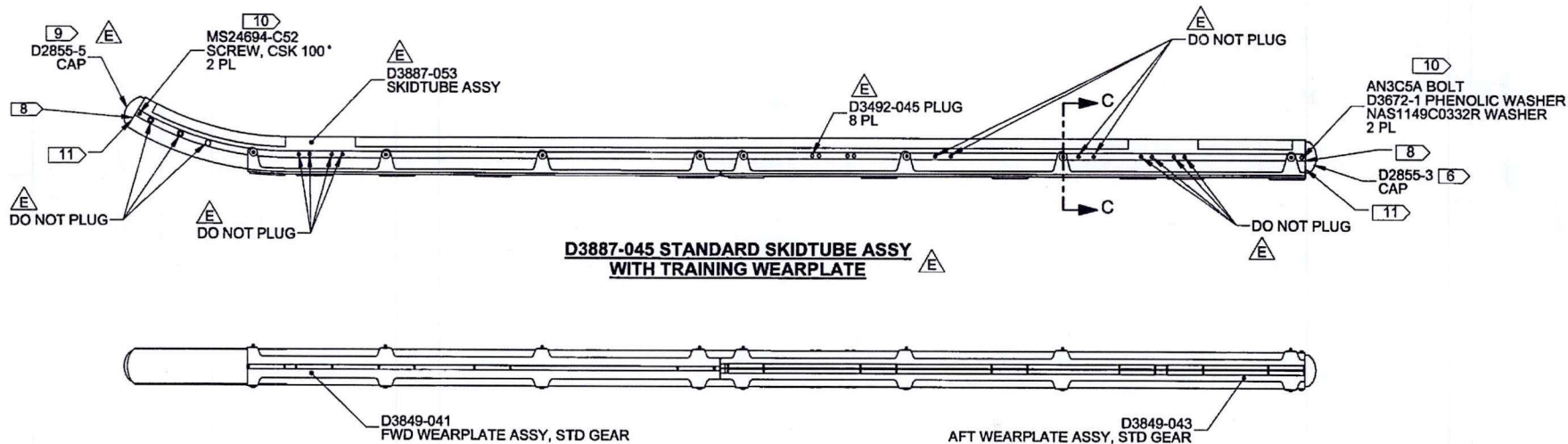
Specifications could not be found.

Plex 3/21/19 10:08 AM Dart.lajeunesse.marie

ITEM	QTY -045	P/N	DESCRIPTION
	X	D3887-045	STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE
1	1	D2855-3	CAP ASSY
2	1	D2855-5	CAP ASSY
3	8	D3492-045	PLUG
4	2	D3672-1	PHENOLIC WASHER
5	1	D3849-041	FWD WEARPLATE ASSY, STD GEAR
6	1	D3849-043	AFT WEARPLATE ASSY, STD GEAR
7	1	D3887-053	SKIDTUBE ASSY
8	16	D3904-1	WASHER
9	1	ALS4-1032-225	INSERT
10	8	AN3C46A	BOLT
11	2	AN3C5A	BOLT
12	8	MS21043-3	NUT, SELF-LOCKING
13	2	MS24694-C52	SCREW, CSK 100°
14	2	NAS1149C0332R	WASHER



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MJS
190321



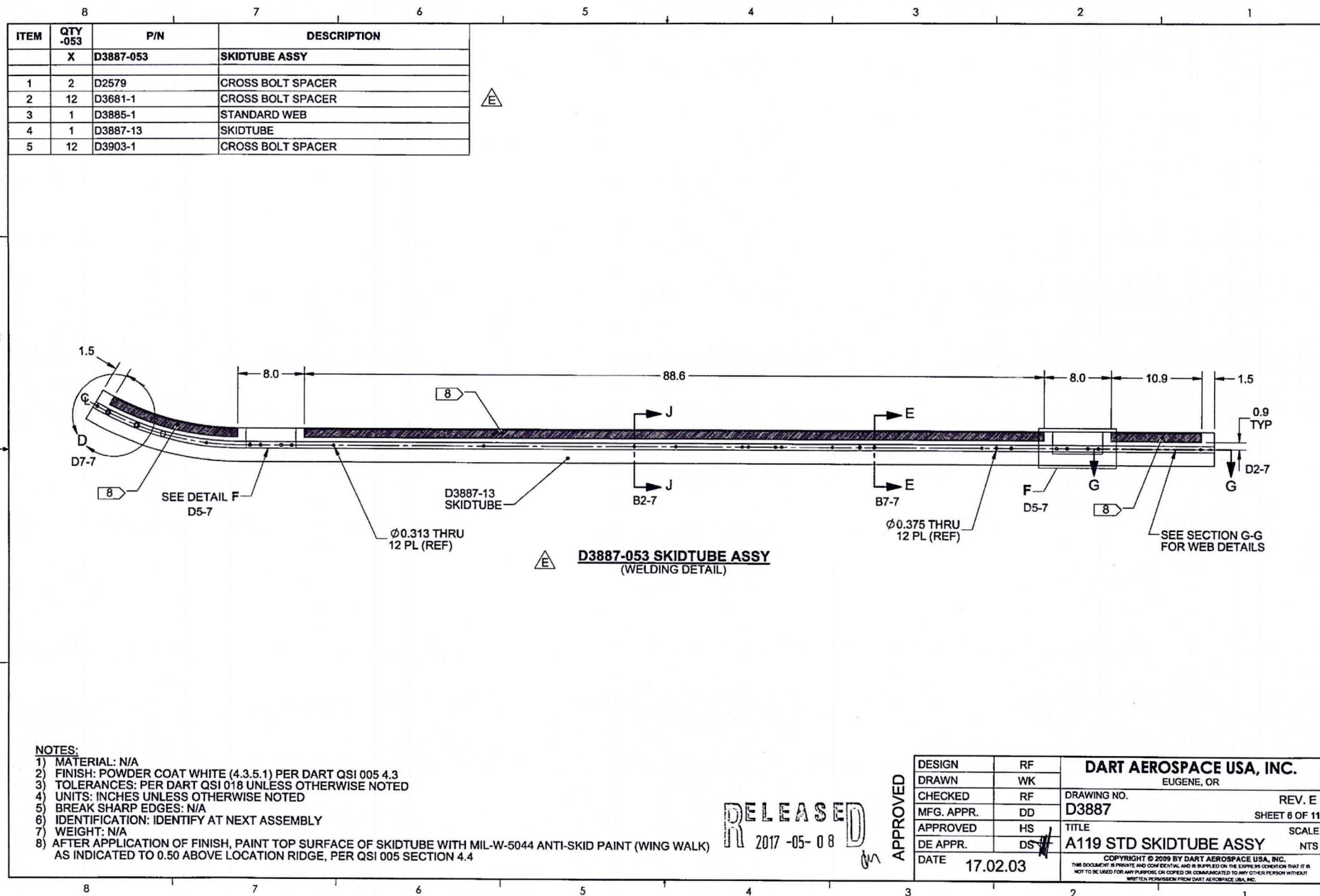
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3887-045" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 38.1 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3887-053 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP. OPEN HOLE TO Ø0.297, ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

RELEASED
2017-05-08

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	WK	EUGENE, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3887	SHEET 4 OF 11
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 STD SKIDTUBE ASSY	NTS
DATE	17.02.03	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



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D

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C

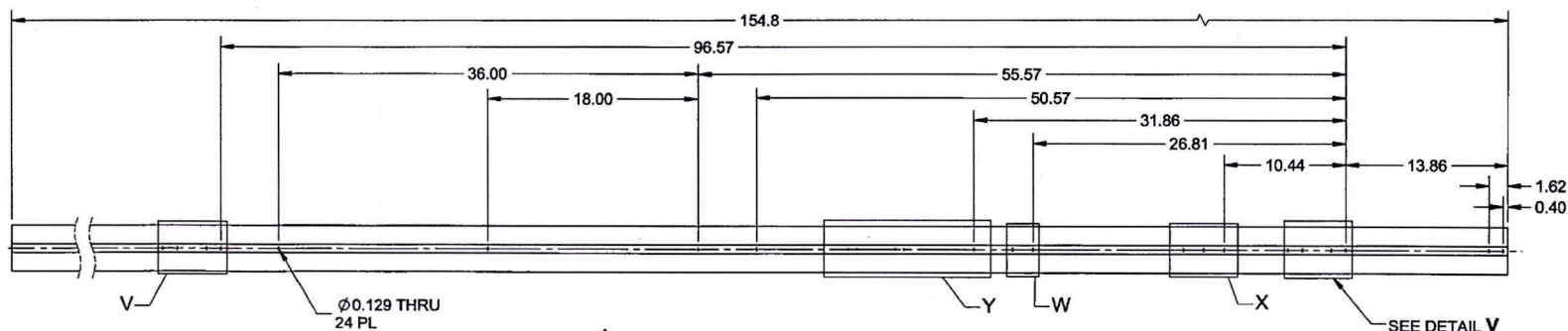
C

B

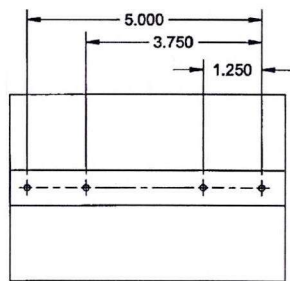
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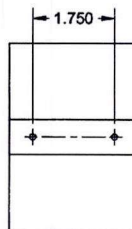
A



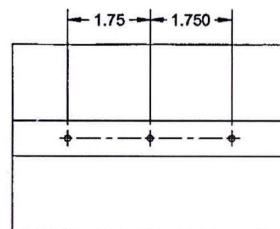
D3887-3 PILOT HOLE DETAIL SKIDTUBE



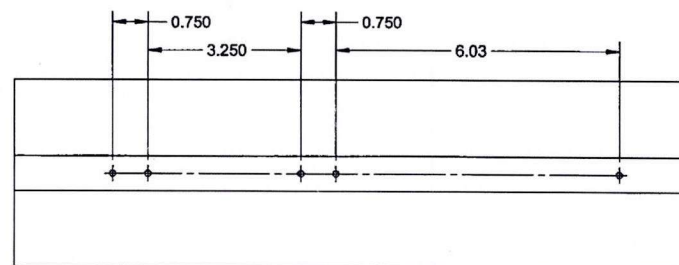
DETAIL V
SCALE 4X
2 PL



DETAIL W
SCALE 4X



DETAIL X
SCALE 4X



DETAIL Y
SCALE 4X

- NOTES:**
 1) MATERIAL: MAKE FROM D2500-1-190 EXTRUSION
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 7) WEIGHT: N/A

RELEASED
2017-05-08

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DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	WK	EUGENE, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3887	SHEET 11 OF 11
APPROVED	HS	TITLE	SCALE
DE APPR.	D3	A119 STD SKIDTUBE ASSY	NTS
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8 7 6 5 4 3 2 1

Change Record

PAGE 1 OF 1

Part Number: D119-646-241

Description: REPLACEMENT STD SKIDTUBE w/ TRAINING WEARPLATES

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